SERVICE PARTS LIST

BULLETIN NO. 54-38-1760

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS	REVISED BULLETIN	DATE
6" RAT-TAIL ANGLE GRINDER		Jan. 2009
CATALOG NO. 6123-31 STARTING SERIAL NUMBER **B68A**	WIRING INSTRUCTION	**See Reverse Side**

00 | 0 **EXAMPLE:** Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

***LUBRICATION NOTE:** When servicing the Gears (25 & 46) or the Gearcase (15), 90-95% of the old grease must be removed prior to new grease being added.

Rubber Plug (45) is to be placed in a cavity by the bearing bore in the back of Motor Housing (44).

Functionally check Spindle Lock mechanism. Spindle Lock must return briskly when released from engagement in Gear (25).

NOTE: Torque Armature Nut (1) to 47 in/lbs, 55 kg/cm.

Orient Needle Bearing (14) such that side with vendor I.D. is facing Gear (25).

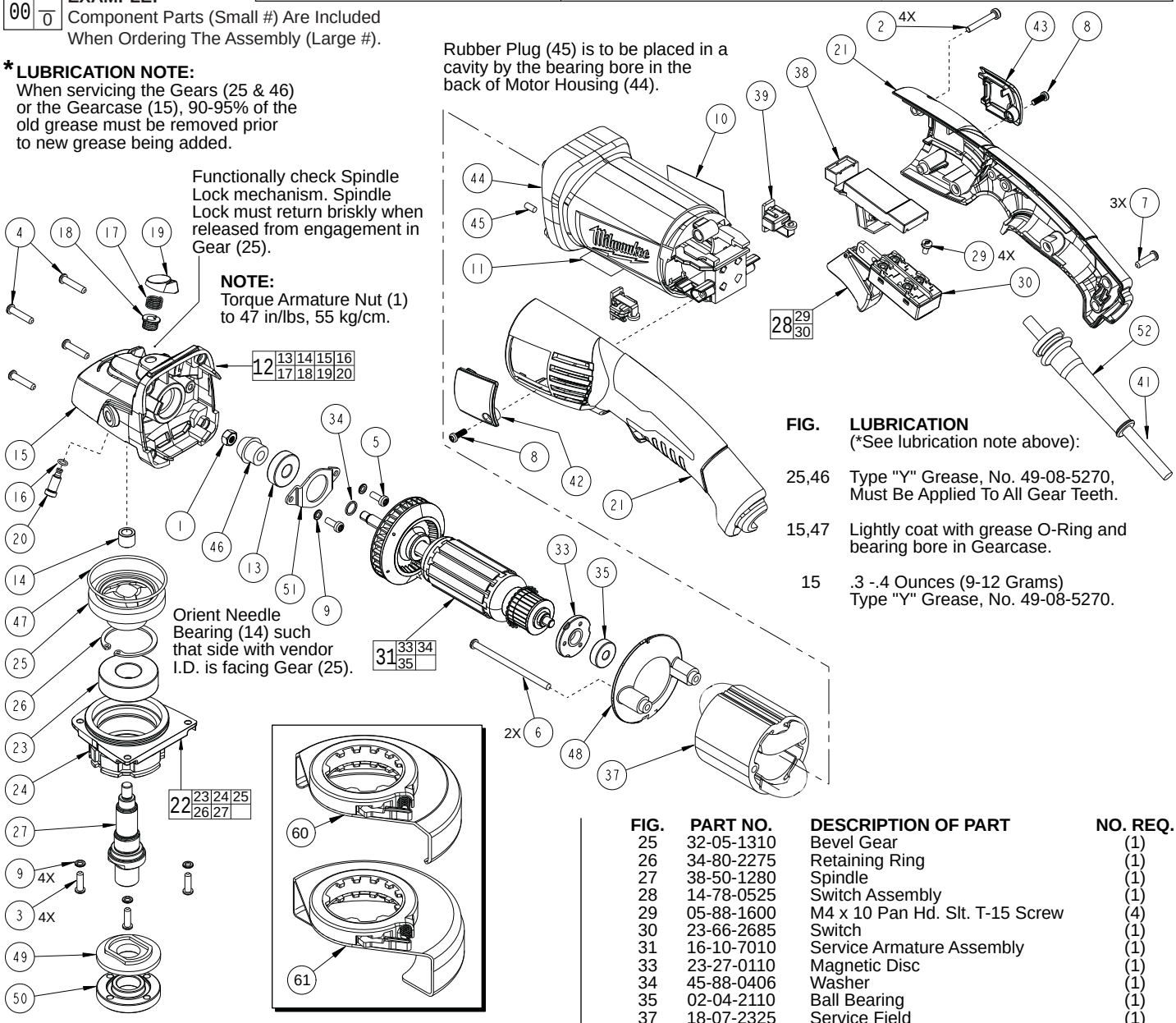
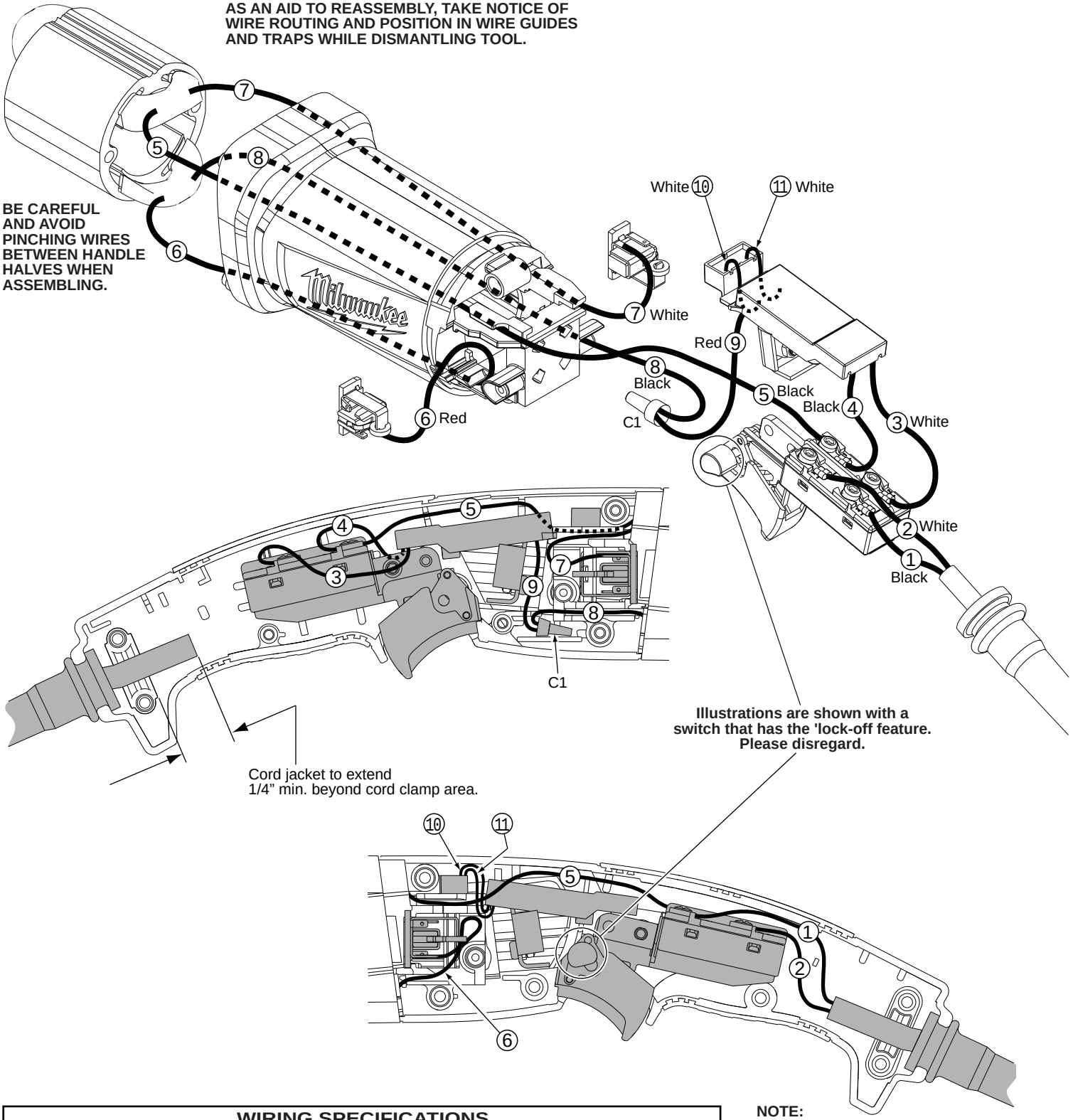


FIG.	LUBRICATION (*See lubrication note above):
25,46	Type "Y" Grease, No. 49-08-5270, Must Be Applied To All Gear Teeth.
15,47	Lightly coat with grease O-Ring and bearing bore in Gearcase.
15	.3 -.4 Ounces (9-12 Grams) Type "Y" Grease, No. 49-08-5270.

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	05-55-0620	M5 Hex Nut	(1)
2	05-88-1200	M4 x 16 Pan Hd. T-20 Screw	(4)
3	05-88-1210	M4 x 14 Pan Hd. T-20 Screw	(4)
4	05-88-1250	M4 x 20 Pan Hd. T-20 Screw	(4)
5	05-88-1280	M4 x 10 Pan Hd. T-20 Screw	(2)
6	05-88-1290	M4 x 76 Pan Hd. T-20 Screw	(2)
7	05-88-1610	M4 x 25 Pan Hd. T-20 Screw	(3)
8	05-88-1650	M3 x 10 Pan Hd. T-10 Screw	(2)
9	05-90-0225	M4 Spring Washer	(6)
10	12-20-6116	Service Nameplate	(1)
11	10-15-1230	Warning Label	(1)
12	14-29-0310	Gearcase Assembly	(1)
13	02-04-0620	Ball Bearing	(1)
14	02-50-1195	Needle Bearing	(1)
15	28-14-0715	Gearcase4	(1)
16	34-40-0450	O-Ring	(1)
17	40-50-1330	Compression Spring	(1)
18	42-42-0580	Spindle Lock Tube	(1)
19	42-42-0590	Spindle Lock Button	(1)
20	44-60-1660	Spindle Lock Pin	(1)
21	14-34-0810	Rear Handle Assembly	(1)
22	14-73-0410	Spindle/Hub Assembly	(1)
23	02-04-1150	Ball Bearing	(1)
24	28-53-0410	Lower Gearcase Hub	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
25	32-05-1310	Bevel Gear	(1)
26	34-80-2275	Retaining Ring	(1)
27	38-50-1280	Spindle	(1)
28	14-78-0525	Switch Assembly	(1)
29	05-88-1600	M4 x 10 Pan Hd. Slt. T-15 Screw	(4)
30	23-66-2685	Switch	(1)
31	16-10-7010	Service Armature Assembly	(1)
33	23-27-0110	Magnetic Disc	(1)
34	45-88-0406	Washer	(1)
35	02-04-2110	Ball Bearing	(1)
37	18-07-2325	Service Field	(1)
38	22-09-1800	PC Board	(1)
39	22-22-1560	Carbon Brush Assembly	(2)
41	22-64-2020	Cord	(1)
42	31-15-2205	Brush Cover - Left	(1)
43	31-15-2200	Brush Cover - Right	(1)
44	31-50-2600	Motor Housing	(1)
45	31-53-0240	Plug	(1)
46	32-60-1310	Bevel Pinion	(1)
47	34-40-0560	O-Ring	(1)
48	42-14-0490	Fan Baffle	(1)
49	43-34-0036	Disk Flange	(1)
50	44-40-0035	Flange Nut	(1)
51	44-66-0450	Bearing Retainer	(1)
52	44-76-0210	Strain Relief	(1)
60	43-54-1080	6" T27 Guard Assembly	(1)
61	43-54-1085	6" T1 Guard Assembly	(1)
	42-62-0100	Side Handle (Not Shown)	(1)
	49-96-7205	Spanner Wrench (Not Shown)	(1)

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. Lisbon Road, Brookfield, WI 53005


AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.
BE CAREFUL AND AVOID PINCHING WIRES BETWEEN HANDLE HALVES WHEN ASSEMBLING.
Milwaukee
White 10
11 White
7 White
Red 9
8 Black
5 Black
Black 4
3 White
C1
6 Red
2 White
1 Black
Cord jacket to extend 1/4" min. beyond cord clamp area.
Illustrations are shown with a switch that has the 'lock-off feature. Please disregard.

WIRING SPECIFICATIONS					
Wire No.	Wire Color	Origin or Part No.	Gauge	Length	Terminals, Connectors and End Wire Preparation
1	Black	22-64-2020	--	--	Component of Cord Set.
2	White	22-64-2020	--	--	Component of Cord Set.
3	White	22-09-1800	--	--	Component of PC Board.
4	Black	22-09-1800	--	--	Component of PC Board.
5	Black	18-07-2325	--	--	Component of Service Field.
6	Red	18-07-2325	--	--	Component of Service Field.
7	White	18-07-2325	--	--	Component of Service Field.
8	Black	18-07-2325	--	--	Component of Service Field.
9	Red	22-09-1800	--	--	Component of PC Board.
10	White	22-09-1800	--	--	Component of PC Board.
11	White	22-09-1800	--	--	Component of PC Board.

BULK LEAD WIRE - BULLETIN 58-01-0003

NOTE:
All leads must be held to ± 1/16".
All lead lengths are before stripping.

TERMINAL DESCRIPTION		
Code	Part No.	Qnty.
CONNECTOR DESCRIPTION		
C1	22-56-0150	1